

Work Order ID 77167 - 1

77167

Soon

Page 1

Item ID: D3779-041
 Revision ID:
 Item Name: Handle Assembly (Exterior)
 Start Date: 28/11/2011 Start Qty: 4.00
 Required Date: 12/12/2011 Req'd Qty: 4.00
 Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: M.L.S Date: 11/11/28 Tooling:
 QC: Date: SPC (Y/N):

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3779	Rev A

100 FLOW WATER JET 0.00

100

Waterjet

FLOW CNC Waterjet

6061. 175

Memo

1-Cut as per Dwg D3779

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

B 11-12-22

(6)

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC

Quality Control

Memo

0.00

B 11-12-22

120 QC8- Inspect parts - second check 0.00

120

QC

Quality Control

Memo

0.00

Sub 12/22

(46)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77167

November-28-11 9:00:09 AM

77167

Page 2

Item ID: D3779-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Handle Assembly (Exterior)

Start Date: 28/11/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/12/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
130									
Small Fab	Memo	0.00							
Small Fab	1- counter sink holes as per dwg D3779 2- deburr								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing									

Handwritten signature and date 11/12/22 with circled 6

Handwritten signature and date 11/12/23

Handwritten circled 6

Handwritten signature and date 11-12-23

Handwritten circled 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 77167

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Page 3

November-28-11 9:00:09 AM

Item ID: D3779-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Handle Assembly (Exterior)
 Start Date: 28/11/2011 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 12/12/2011 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160 QC3- Inspect Part Finish 0.00

160

QC

Quality Control

Memo

0.00

Gx d 11/12/22
counted

180 0.00

180

Small Fab

Small Fab

Small Fab

Memo

0.00

1- rivet D3203-1 handle to D3779-1 plate as per dwg D3779 per QSI003

SB
FF. 12-01-19

4

190 QC5- Inspect part completeness to step on W/O 0.00

190

QC

Quality Control

Memo

0.00

Sizlois

XL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 4

November-28-11 9:00:09 AM

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 Required Date: 12/12/2011 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location <i>234</i>	0.00							
200									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

M.L.J 12/01/20
 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

November-28-11 9:00:14 AM

Page 1

Work Order ID: 77167

77167

Parent Item: D3779-041

D3779-041

Parent Item Name: Handle Assembly (Exterior)

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-06-09 new issue DD verified by:ec
IPP Rev:B 08-07-21 procedure change DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.125

Purchased

No

100

sf

84.7400

0.194

0.816842

1.5

M6061T6S 125

6061-T6 .125 Sheet

**

B11-12-22

Location

Loc Qty

Loc Code

MAT009

4.9

119513

4.9

MAT021

79.84

113608

65.35

118217

14.49

113608

6

D3203-1

Manufactured

No

180

Each

39.0000

1

4

D3203-1

Handle

**

FF 12-01-19

Location

Loc Qty

Loc Code

ST240

39

65003

1

69020

8

73552

30

4

MS20426AD10-8

Purchased

No

180

Each

247.0000

4

16

MS20426AD10-8

Rivets

**

FF 12-01-19

Location

Loc Qty

Loc Code

ST318

247

109681

197

110153

50

M 108 110

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order: 7167

Description: HANDLE ASS

Part Number: D3779-041

Inspection Dwg: D3779-1, Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .191	+ .005 - .001	.194	✓		V B02	
Ø .316	+ .006 - .001	.318	✓		V	
.40 ± .01	.30	.405	2		V	
2.300 ± .01	.01	2.303	2		V	
4.100 ± .01	.01	4.109	2		V	
3.10 ± .01	.01	3.107	2		V	
9.00 ± .01	.01	9.006	8		Plowice	
1.000 ± .01	.01	1.000	2		V	
1.05 ± .01	.01	1.049	2		V	
6.960 ± .01	.01	6.958	2		V	
1.02 ± .01	.01	1.025	2		V	
.125 ± .01	.01	.123	2		V	

Measured by: RB

Audited by: S

Prototype Approval:

Date: 11-12-22

Date: 11/12/22

Date:

Rev	Date	Change
A		New Issue

Revised by	Approved
KJJLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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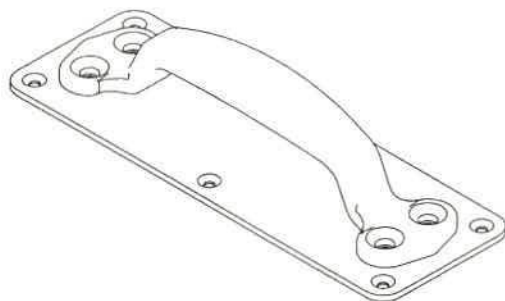
NOTE: Date & initial all entries

QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
X		D3779-041	HANDLE ASSEMBLY
	X	D3779-043	HANDLE ASSEMBLY
1	1	D3203-1	HANDLE
1		D3779-1	PLATE
	1	D3779-5	PLATE
4	4	MS20426AD10-8	RIVET, CSK

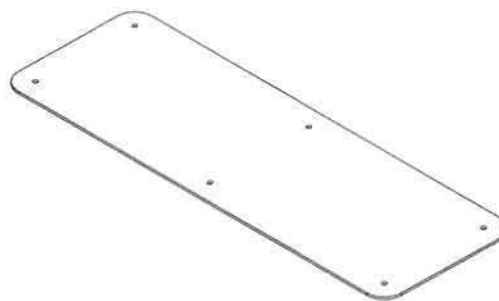
NOT A COPY
 RETURN TO:
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

77167 M.L.J

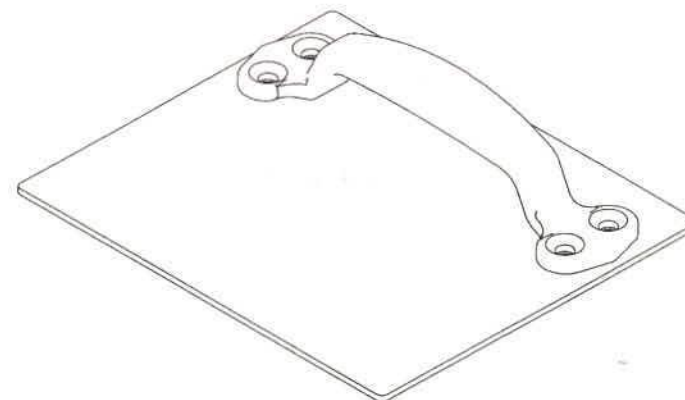
11/11/20



**D3779-041 HANDLE ASSEMBLY
(EXTERIOR)**



D3779-3 DOUBLER PLATE



**D3779-043 HANDLE ASSEMBLY
(INTERIOR)**

RELEASED
16 05 26 111

A	NEW ISSUE	AJS	08.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3779	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		HANDLE ASSEMBLY, CABIN SLIDING DOOR	NTS
DATE	08.04.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

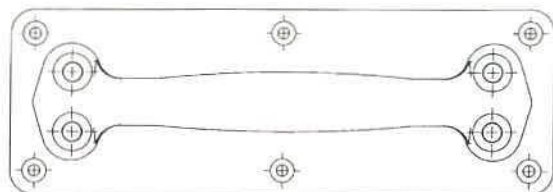
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

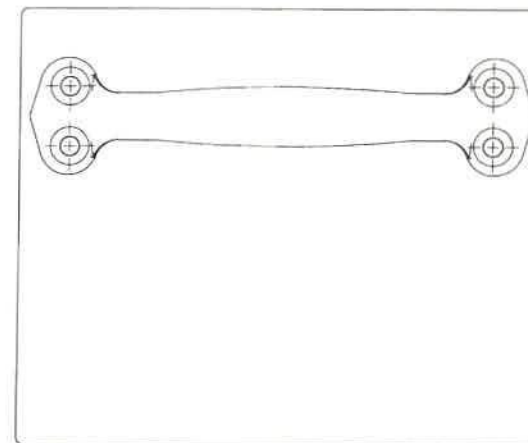
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

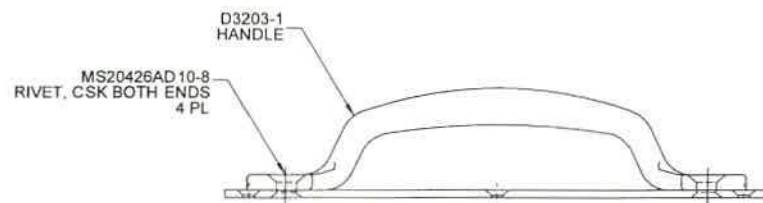
77147



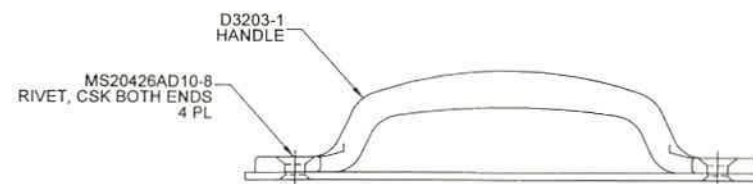
D3779-1
PLATE



D3779-5
PLATE



**D3779-041 HANDLE ASSEMBLY
(EXTERIOR)**



**D3779-043 HANDLE ASSEMBLY
(INTERIOR)**

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-041" USING FINE POINT PERMANENT INK MARKER
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-043" USING FINE POINT PERMANENT INK MARKER
- 8) WEIGHT: 0.71 lbs APPROX (-041)
- 9) WEIGHT: 1.14 lbs APPROX (-043)

RELEASED
08-06-26 18

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWN	AJS		
CHECKED		DRAWING NO. D3779	SHEET 2 OF 4
MFG. APPR.		TITLE HANDLE ASSEMBLY, CABIN SLIDING DOOR	SCALE NTS
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR OWNED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	08.04.21		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

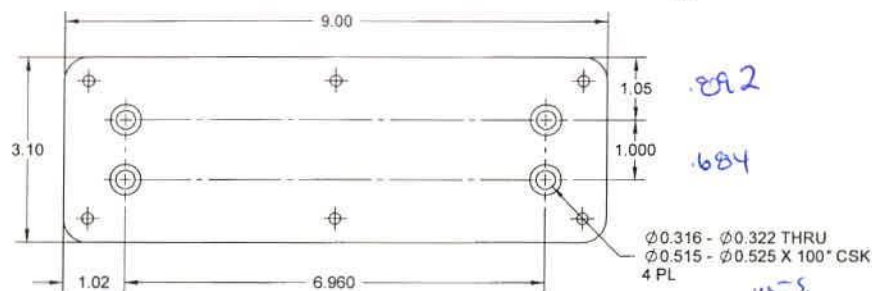
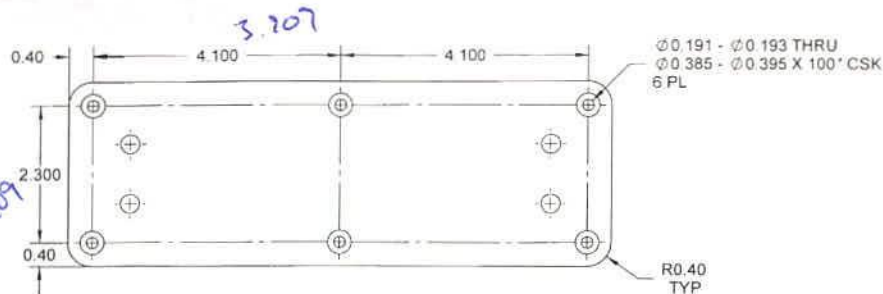
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

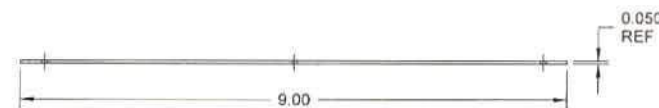
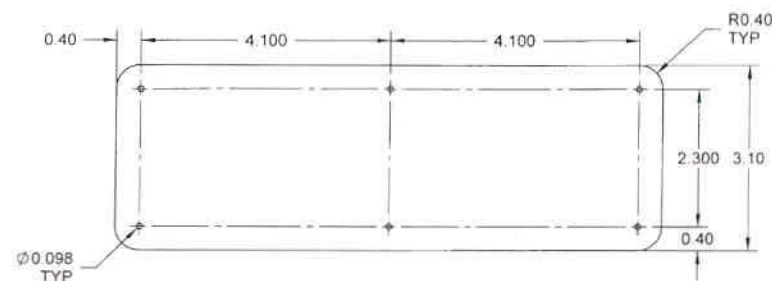
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77167



D3779-1 PLATE



D3779-3 PLATE

NOTES:

1) MATERIAL: -1 PLATE:

6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.125

-3 PLATE:

6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.050

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-3" USING FINE POINT PERMANENT INK MARKER
(DO NOT IDENTIFY -1 & -5)

7) WEIGHT: 0.14 lbs FOR -3.

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DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG APPR		D3779	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR		HANDLE ASSEMBLY, CABIN SLIDING DOOR	NTS
DATE	08.04.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
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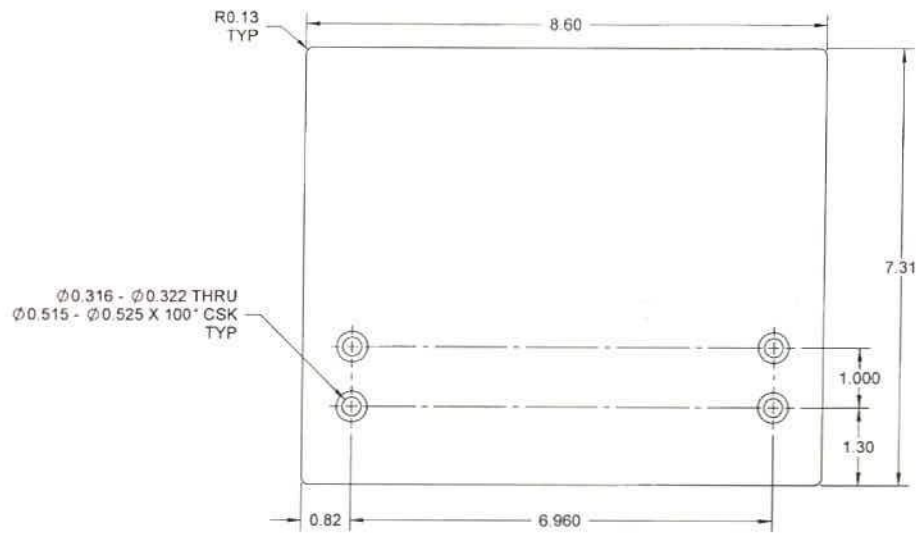
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77167



D3779-5 PLATE

NOTES:

- 1) MATERIAL: -5 PLATE:
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE SHEET 2 FOR ASSEMBLED WEIGHT

RELEASED
08-06-26

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3779	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		HANDLE ASSEMBLY, CABIN SLIDING DOOR	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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